

Work Order ID 159411

Tuesday, April 11, 2017 8:34:35 AM

159411

Page 1

Item ID: D066-1016-115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Basket Mounting Provisions
Start Date: 5/9/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/19/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/S
Approvals: Process Plan:  Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1016	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1016-115 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

MAY 09 2017

DAS
27
9-89

MAY 18 2017

DAS
6
9-89
MAY 17 2017
DAS
28
9-89DAS
27
9-89

MAY 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 159411***159411***

Page 2

Tuesday, April 11, 2017 8:34:35 AM

Item ID: D066-1016-115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Basket Mounting Provisions
Start Date: 5/9/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/19/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1016-115 Location: PPP159413								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS 27 9-89
MAY 18 2017
17/5/19 98
u 1705-19

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER :			

Picklist Print

Tuesday, April 11, 2017 8:34:35 AM

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Work Order ID: 159411

159411

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 5/9/2017

Required Date: 5/19/2017

Start Qty: 1.00

Required Qty: 1.00

D5358-1 Manufactured No

110 Each

0.0000

2

2

D5358-1

Cover Plate

**

159085 MAY 17 2017

DAS 6 28 9-89

D5445-041 Manufactured No

110 Each

0.0000

1

1

D5445-041

Longitudinal Beam Assembly, LH

**

159657

DAS 6 28 9-89

D5445-042 Manufactured No

110 Each

0.0000

1

1

D5445-042

Longitudinal Beam Assembly, RH

**

1596495 MAY 18 2017

DAS 6 28 9-89

MS20392-4C57 Purchased No

110 Each

0.0000

4

4

MS20392-4C57

Pin

**

137361 MAY 17 2017

DAS 6 28 9-89

MS24665-229 Purchased No

110 Each

181.0000

4

4

MS24665-229

Cotter Pin

**

MAY 17 2017

DAS 6 28 9-89

Location

Loc Qty

Loc Code

GA

2

118234

2

ST289

179

m135671

179

MS27151-7 Purchased No

110 Each

12.0000

8

8

MS27151-7

PAL NUT

**

MAY 17 2017

DAS 6 28 9-89

Location

Loc Qty

Loc Code

ST275

12

119902

3

m134055

9

3

Tuesday, April 11, 2017 8:34:35 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Picklist Print

Tuesday, April 11, 2017 8:34:35 AM

Work Order ID: 159411

159411

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 5/9/2017

Required Date: 5/19/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

1,560.000

8

8

NAS1149D0463J

Washer

**

MAY 17 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

48

M135056

48

ST260a

600

M137166

600

ST263

912

M136983

912

137387

NAS1149F0563P

Purchased

No

110

Each

225.0000

4

4

NAS1149F0563P

Washer

**

MAY 17 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST2360A

200

m136983

200

ST262

25

m134852

25

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST

Qty -011	Qty -012	Qty -111	Qty -113	Qty -115	Qty -121	Qty -123	Part Number	Description
X							D066-1016-011	R66 QR HELI-UTILITY-BASKET, LH
	X						D066-1016-012	R66 QR HELI-UTILITY-BASKET, RH
		X					D066-1016-111	CROSSTUBE CLAMP KIT
			X				D066-1016-113	CROSSTUBE CLAMP + LONGITUDINAL BEAM KIT
1	1			X			D066-1016-115	BASKET MOUNTING PROVISIONS KIT
					X		D066-1016-121	FWD LID GAS SPRING UPGRADE (OPTIONAL)
						X	D066-1016-123	FWD FIXED STEP UPGRADE (OPTIONAL)
1							D5337-011	BASKET ASSEMBLY, LH
	1						D5337-012	BASKET ASSEMBLY, RH
					2		D3953-17	GAS SPRING SPACER
					1		D3953-19	GAS SPRING BRACKET
					1		D3953-21	GAS SPRING BRACKET
					2		D3953-3	GAS SPRING STUD
					2		D3953-7	GAS SPRING SPACER
					2		D3953-9	GAS SPRING WASHER
					1		D3969-7	GAS SPRING
				1			D5350-041	R66 FWD CROSS BEAM ASSEMBLY
				1			D5350-043	R66 AFT CROSS BEAM ASSEMBLY
		4	4	4			D5352-1	CUSHION
		1	1	1			D5354-041	R66 FWD CLAMP ASSEMBLY, LH
		1	1	1			D5354-042	R66 FWD CLAMP ASSEMBLY, RH
		2	2	2			D5355-041	R66 AFT CLAMP ASSEMBLY
1	1						D5357-041	STRUT ASSEMBLY
		2	2	2			D5358-1	COVER PLATE
			1	1			D5445-041	LONGITUDINAL BEAM ASSEMBLY, LH
			1	1			D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
						1	D5510-041	FWD STEP
					2		AN310C4	NUT, CASTELLATED
					4		AN3-14A	BOLT
			8	8			AN4-12A	BOLT
						2	AN4-14A	BOLT
				4			MS20392-4C57	PIN
					4		MS21042L3	NUT
						2	MS21042L4	NUT
				4			MS24665-229	COTTER PIN
					2		MS24665-300	COTTER PIN
		8	8	8			MS27151-7	STAMPED NUT
					2		NAS1149C0432R	WASHER
			8	8		4	NAS1149D0463J	WASHER
				4			NAS1149F0563P	WASHER
					8		NAS1149F0332P	WASHER

Work Order ID 159411

159411

Tuesday, April 11, 2017 8:34:35 AM

Item ID: D066-1016-115

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R66 Basket Mounting Provisions

Start Date: 5/9/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/19/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/S

Run Start *NR1*

Approvals: Process Plan:

Date: APR 19 2017 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D066-1016	B

MAY 09 2017

100 Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D066-1016-115 CHG001

CB

MAY 09 2017

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control